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# EUROPEAN PATENT APPLICATION

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(54) Simulated cashmere fabric, and method of producing the same.

(57) A simulated cashmere fabric comprises a warp knit ground comprising a stretch yarn such as an elastomeric yarn such as Lycra (RTM) and a raised and cropped face. The face yarn may be knitted in over a plurality of, say five, needles, and the fabric may be dyed before the raising and cropping steps and crushed and steamed after.

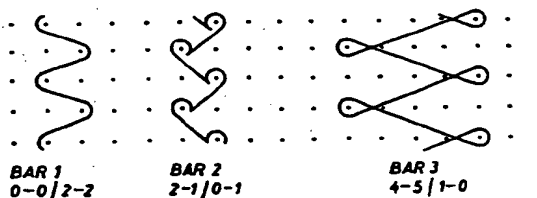


FIG.1

TITLE MODIFIED  
see front page

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FABRIC AND METHOD

This invention relates to simulated cashmere fabric and methods for making the same.

5

The invention comprises a simulated cashmere fabric comprising a warp-knit ground comprising a stretch yarn and a raised and cropped face.

10

The stretch yarn, may be an elastomeric yarn such as "Lycra" -(Registered Trade Mark).

15

The ground fabric may be a two-bar fabric, and may comprise different yarns.

20

The ground fabric may comprise a continuous filament yarn, such as polyester, which may be untexturised.

25

The face yarn may be a continuous filament yarn, which may again be an untexturised multifilament polyester yarn.

The face yarn may be knitted over a plurality of needles, for example over five needles.

Preferably, the face yarn is of the same material as is comprised in the fabric, so that the face yarn and one ground yarn can be the same multifilament polyester yarn. The raised and cropped pile, 5 simulating the hairyness of a cashmere fabric, will then dye to the same shade as the ground fabric, giving the effect that the pile is an integral part of the ground fabric.

10 The invention also comprises a method for making a simulated cashmere fabric comprising warp-knitting a ground fabric together with a face yarn and raising and cropping the face yarn.

15 The fabric may be dyed before the raising and cropping steps, and may be crushed and steamed after the raising and cropping steps.

One embodiment of a simulated cashmere fabric 20 and a method for making the same according to the invention will now be described with reference to the accompanying drawings in which:-

Figure 1 is a point pattern diagram showing the 25 motions of the bars of a warp knitting machine for knitting the fabric, and

Figure 2 is a schematic diagram showing the various steps required in cropping and raising and finishing the fabric.

5           A three bar warp knitting machine is threaded on Bar 1 with a full set of a 44 d/tex "Lycra" (Registered Trade Mark) or similar elastomeric yarn, on Bar 2 and Bar 3 with 76 d/tex 30 filament bright round polyester yarn, full set threading in each case. The motions of the bars set on the pattern chain are illustrated in Figure 1. Bar 1 lays-in the elastomeric yarn over adjacent needles, Bar 2 knits a tricot base fabric with the laid-in elastomeric yarn, while Bar 3 knits in the face yarn over five needles so that there are long floats of this face yarn which are broken during the raising step and subsequently cropped to leave a fine pile of relatively short "hairs" on the face of the fabric.

20           As seen in Figure 2, the knitted fabric, prior to the raising and cropping steps, is dyed. The face yarn and the tricot ground yarn being the same polyester yarn, of course, dye to the same shade. Elastomeric yarns such as "Lycra" (Registered Trade Mark) are temperature-sensitive, so the dyeing should be carried out at a suitably low temperature. Dyeing at less than 115°C is necessary in the case of "Lycra".

The dyeing step is followed by a hot stentering step, after which the fabric is raised under high tension, then the raised pile cropped. This is  
5 followed by a crushing and steaming step, followed by a second hot stentering step. The fabric can then be packed for sale.

Simulated stretch cashmere fabric made as  
10 described is suitable inter alia as an automobile upholstery fabric.

CLAIMS

1. A simulated cashmere fabric comprising a  
warp-knit ground comprising a stretch yarn and a raised  
and cropped face.

2. A fabric according to claim 1, in which the  
stretch yarn comprises an elastomeric yarn.

3. A fabric according to claim 1 or claim 2, in  
which the ground fabric is a two-bar fabric.

4. A fabric according to any one of claims 1 to 3,  
in which the ground fabric comprises different yarns.

5. A fabric according to any one of claims 1 to 4,  
in which the ground fabric comprises a continuous  
filament yarn.

6. A fabric according to claim 5, in which the  
continuous filament yarn is polyester.

7. A fabric according to claim 5 or claim 6, in  
which the continuous filament yarn is untexturised.

8. A fabric according to any one of claims 1 to 7,  
in which the face yarn is a continuous filament yarn.



9. A fabric according to claim 8, in which the face yarn is an untexturised multifilament polyester yarn.

10. A fabric according to any one of claims 1 to 9,  
5 in which the face yarn is knitted in over a plurality of needles.

11. A fabric according to claim 10, in which the face yarn is knitted in over five needles.

10

12. A fabric according to any one of claims 1 to 11, in which the face yarn is of the same material as is comprised in the ground.

15 13. A fabric according to claim 12, in which the face yarn and one ground yarn comprise polyester.

14. A fabric according to any one of claims 1 to 13, which has been crushed and steamed after the face has  
20 been brushed and cropped.

15. A method for making simulated cashmere fabric comprising warp-knitting a ground fabric from a stretch yarn together with a face yarn and raising and cropping  
25 the face yarn.

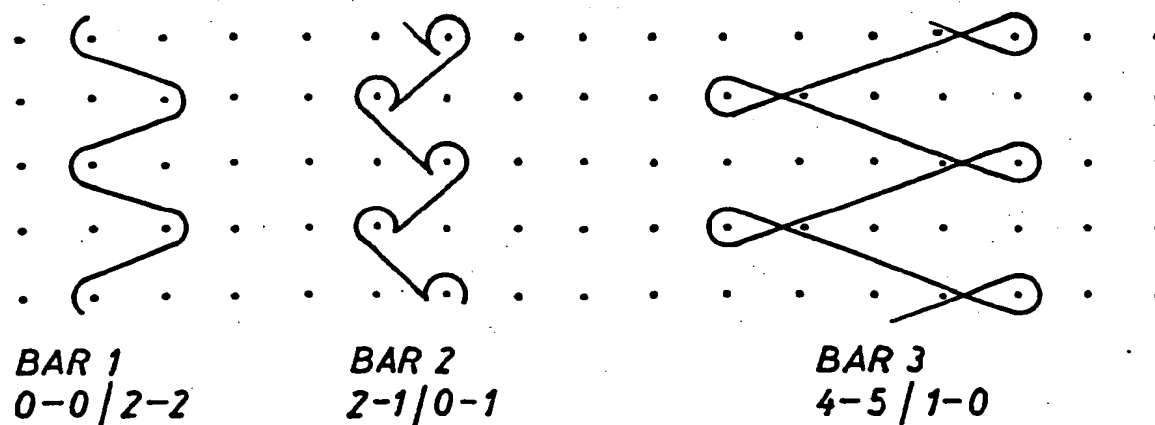
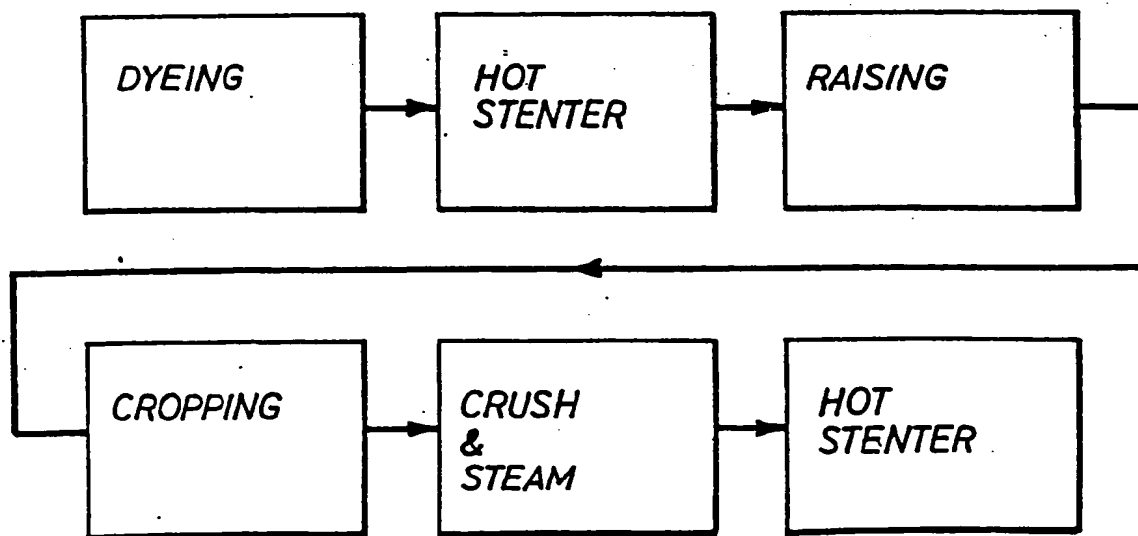
16. A method according to claim 15, in which the  
5 face yarn is the same material as at least one yarn of  
the ground fabric.

17. A method according to claim 15, in which the  
10 ground fabric is knitted from an elastomeric  
yarn.

18. A method according to claim 15, in which the  
15 fabric is dyed prior to the raising and cropping steps.

19. A method according to claim 15, in which the  
fabric is crushed and steamed after the raising and  
cropping steps.

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FIG.1FIG.2



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# EUROPEAN SEARCH REPORT

0111409

Application number

EP 83 30 7330

## DOCUMENTS CONSIDERED TO BE RELEVANT

| Category   | Citation of document with indication, where appropriate, of relevant passages                         | Relevant to claim       | CLASSIFICATION OF THE APPLICATION (Int. Cl. 3) |
|--|---|-------------------------|--|
| A  | DE-A-2 843 250 (KARL MAYER)<br><br>* Claim 1; page 6, lines 1-4; page 8, lines 13-22; figures 1,4,5 * | 1-4,10<br>,11,15<br>,17 | D 04 B 21/04                                   |
| A  | GB-A-1 557 328 (DALEMAR)<br><br>* Claims 1,5,7; figures 1-3 *   | 1,3,4,<br>5,6,10        |  |
| A  | FR-A-2 189 559 (SANDOZ)<br>* Page 2, line 33 - page 3, line 20 *                                      | 1,15                    |  |
| A  | DE-A-2 364 587 (GELSENBERG FASERWERKE)  |                         |  |
| A  | US-A-3 254 510 (LESLEY)   |                         |  |
| A  | FR-A-1 075 266 (FABELTA)  |                         |  |
| A  | FR-A-1 564 719 (GERHARD RÖSCH)  |                         |  |
| A  | GB-A-1 172 502 (ROKANA TEXTILWERZ)  |                         |  |
| The present search report has been drawn up for all claims |   |                         |  |
|  |   |                         | TECHNICAL FIELDS SEARCHED (Int. Cl. 3)         |
|  |   |                         | D 04 B<br>D 06 C                               |

Place of search  
THE HAGUE

Date of completion of the search  
15-03-1984

Examiner  
VAN GELDER P.A.

### CATEGORY OF CITED DOCUMENTS

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| Category  | Citation of document with indication, where appropriate, of relevant passages | Relevant to claim  | CLASSIFICATION OF THE APPLICATION (Int. Cl. 3) |
| A   | GB-A-1 204 384 (BAYER)<br><br>-----   |  |  |
|   |   |  | TECHNICAL FIELDS SEARCHED (Int. Cl. 3)         |
|   |   |  |  |
| The present search report has been drawn up for all claims  |   |  |  |
| Place of search<br>THE HAGUE  |   | Date of completion of the search<br>15-03-1984   | Examiner<br>VAN GELDER P.A.                    |
| <b>CATEGORY OF CITED DOCUMENTS</b>  |   |  |  |
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